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**Erné**

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(54) **SENSOR SYSTEM FOR PATTY FORMING MACHINE AND METHOD OF USE**

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See application file for complete search history.

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(51) **Int. Cl.**  
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*A23P 30/10* (2016.01)

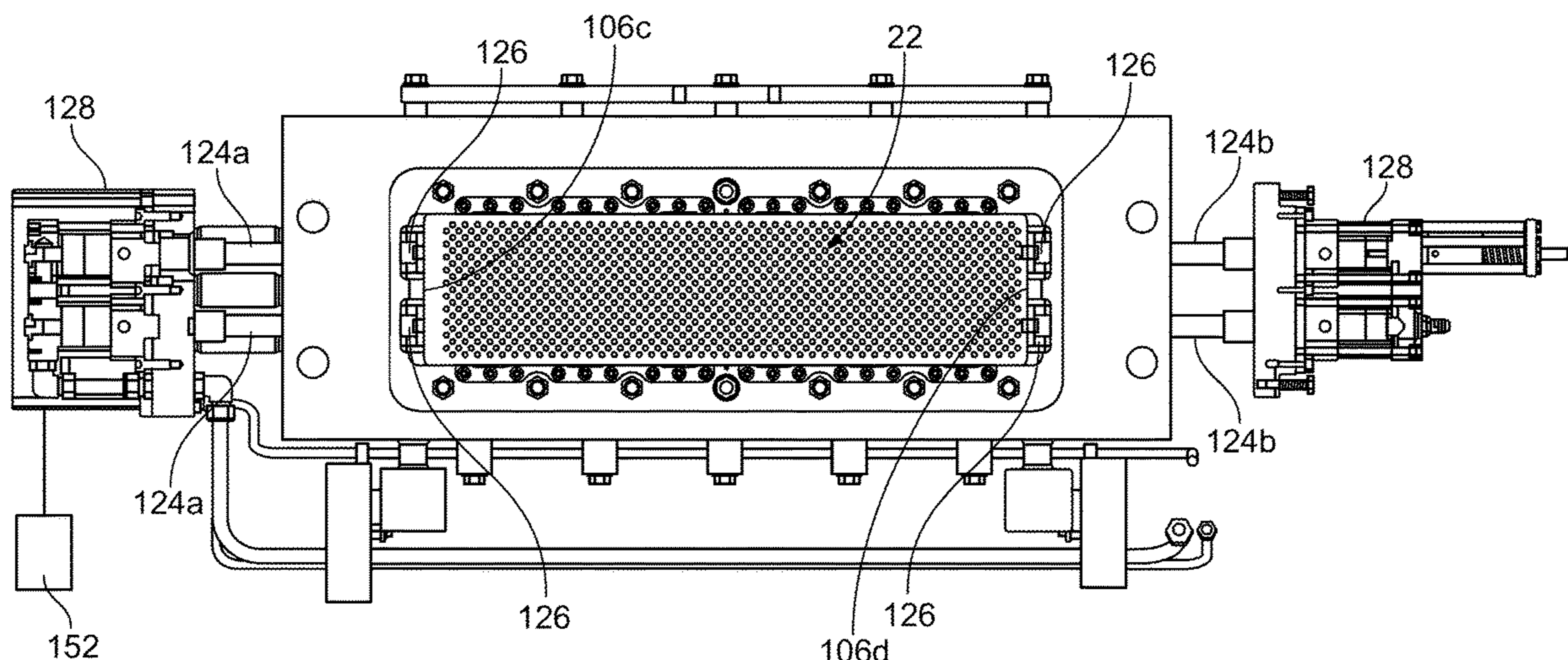
(57) **ABSTRACT**

A patty forming machine configured to mold food products, and its method of use, is provided. The patty forming machine includes a stripper plate through which food product is configured to pass when the stripper plate is in a fill position, a sensor configured to determine positions of the stripper plate, a movable mold, and a sensor configured to determine positions of the mold. A processor is operatively coupled with the sensors. The processor is configured to receive information from the sensors and to determine when the stripper plate is to be moved from the non-fill position to the fill position relative to a determined position of the mold.

(52) **U.S. Cl.**  
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**4 Claims, 15 Drawing Sheets**



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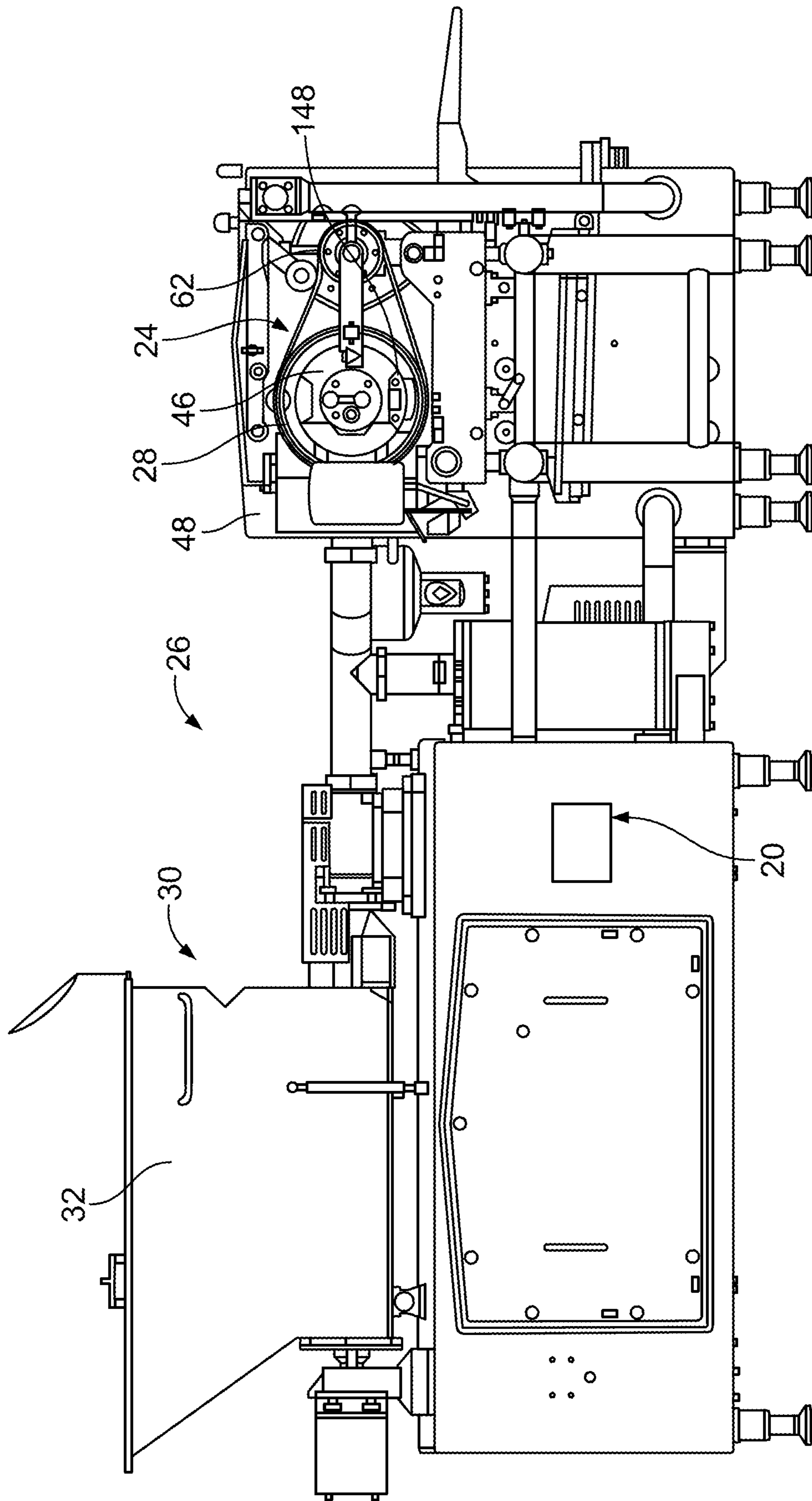


FIG. 1

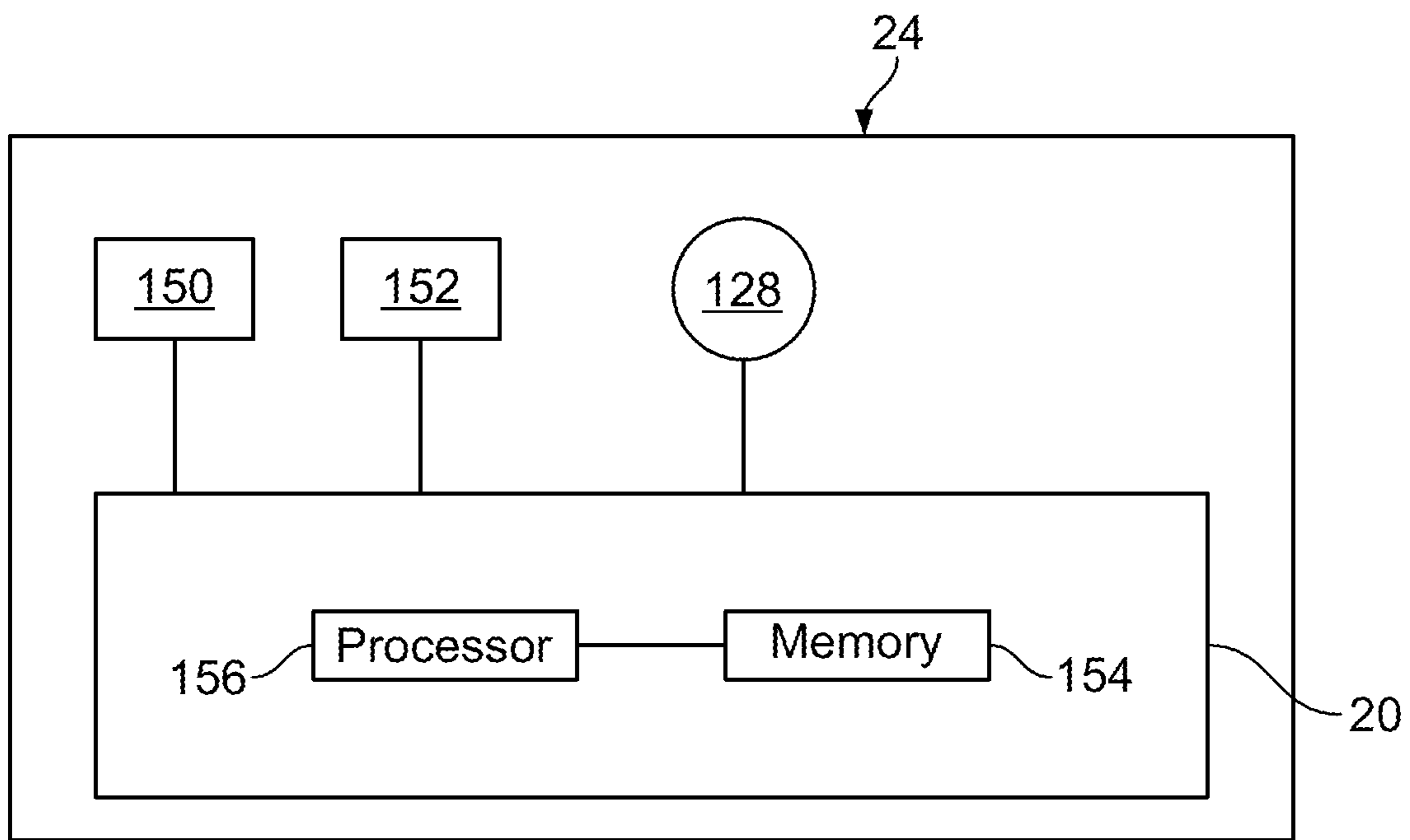
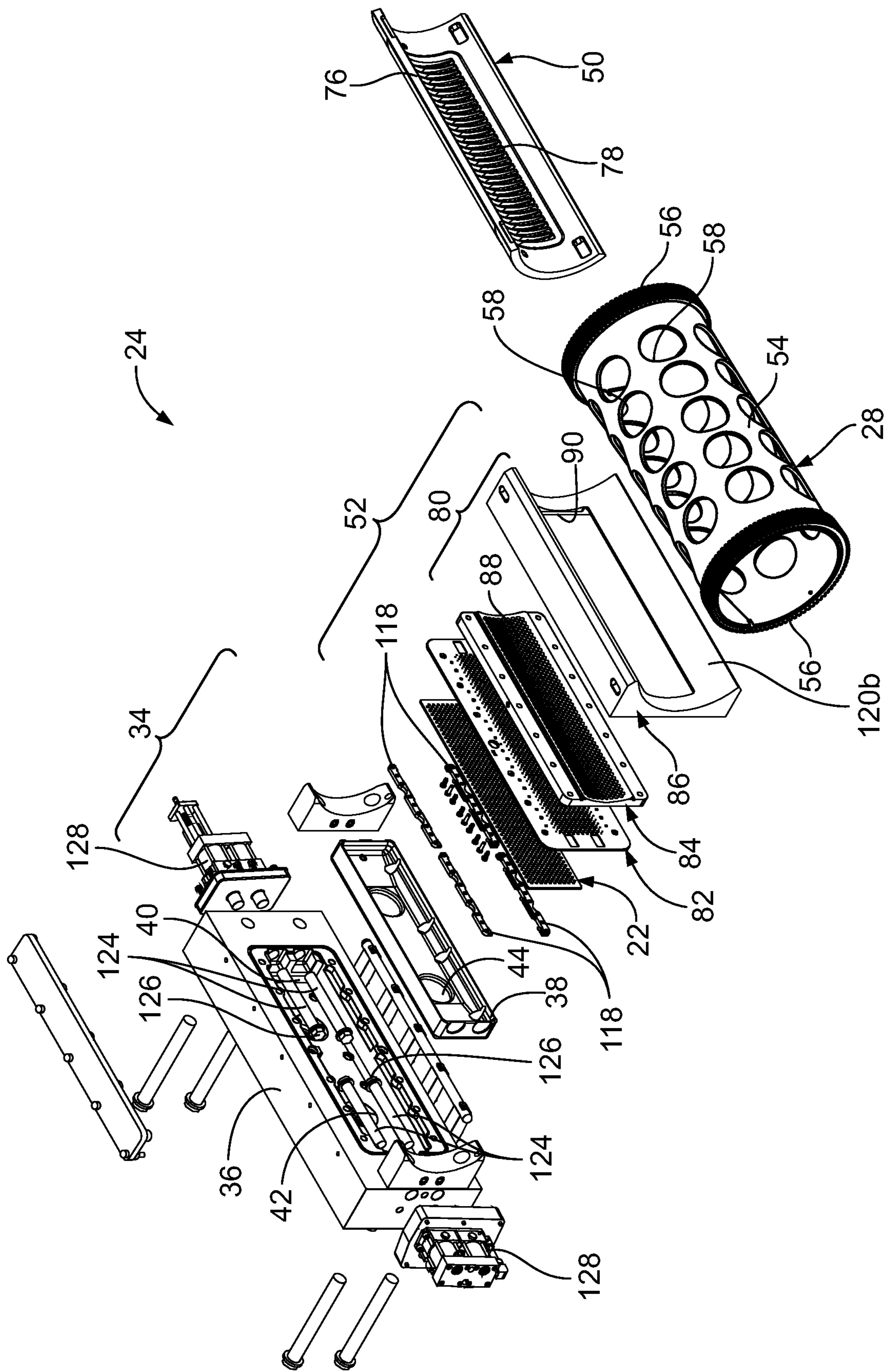


FIG. 2



120b

FIG. 3

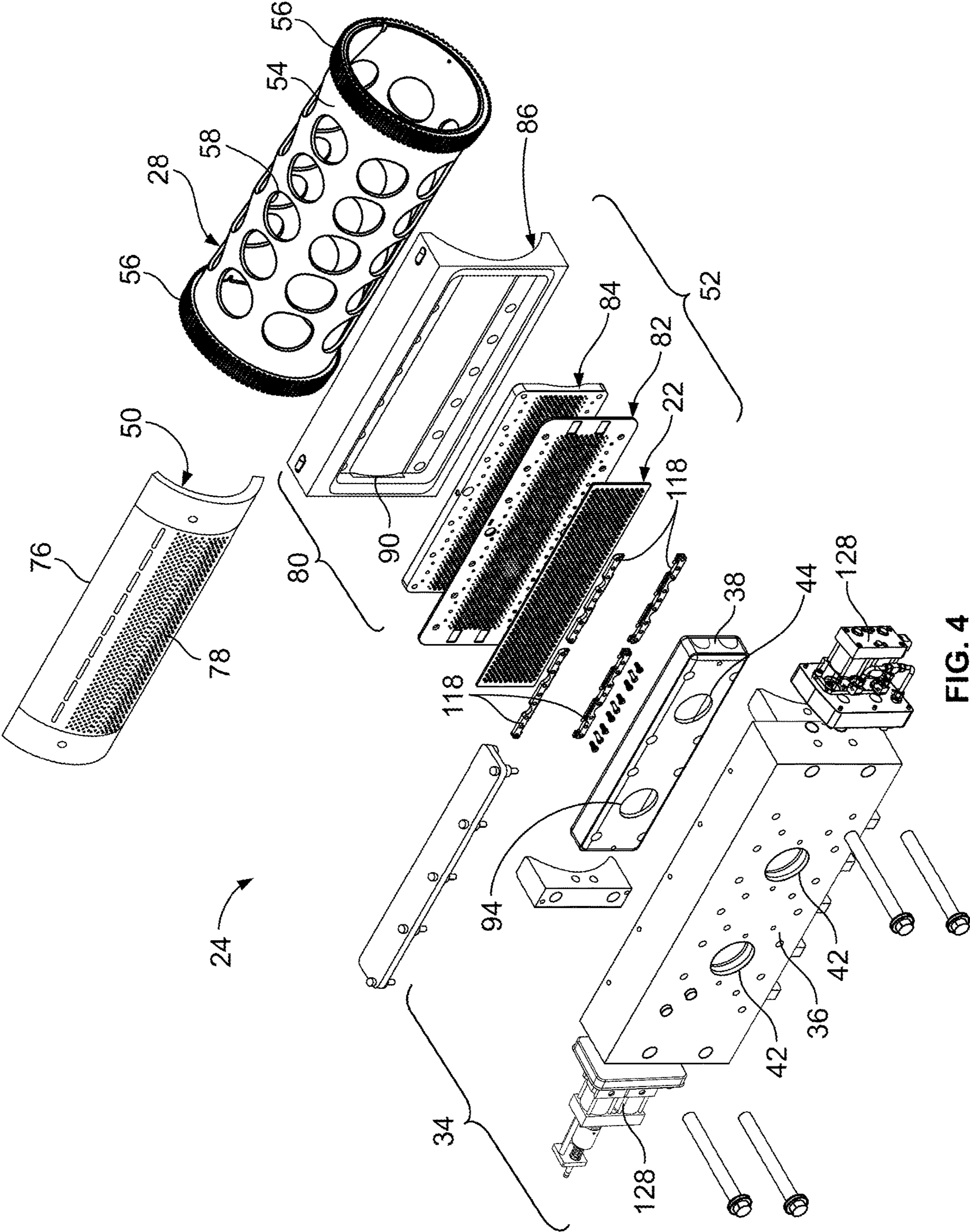


FIG. 4

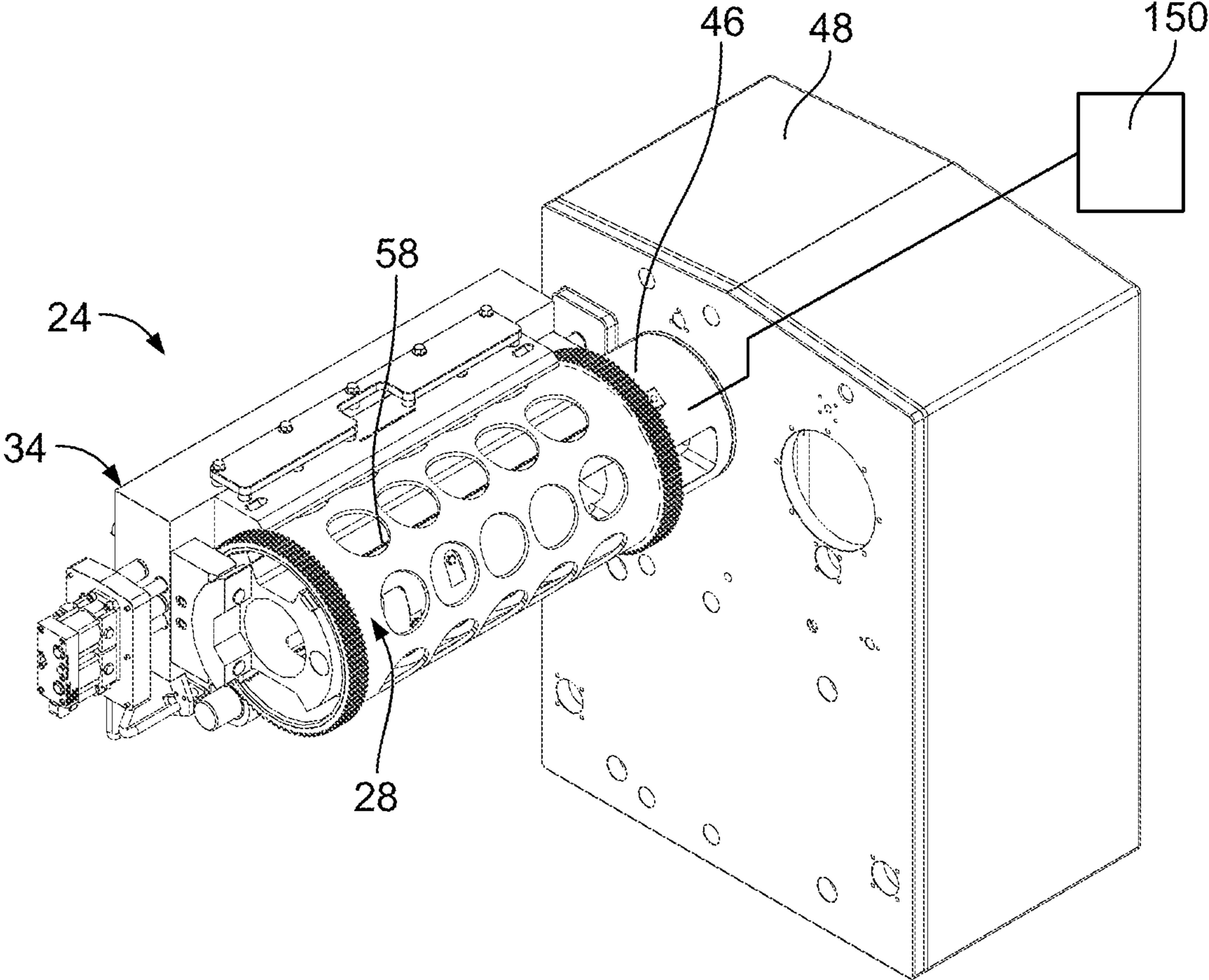


FIG. 5

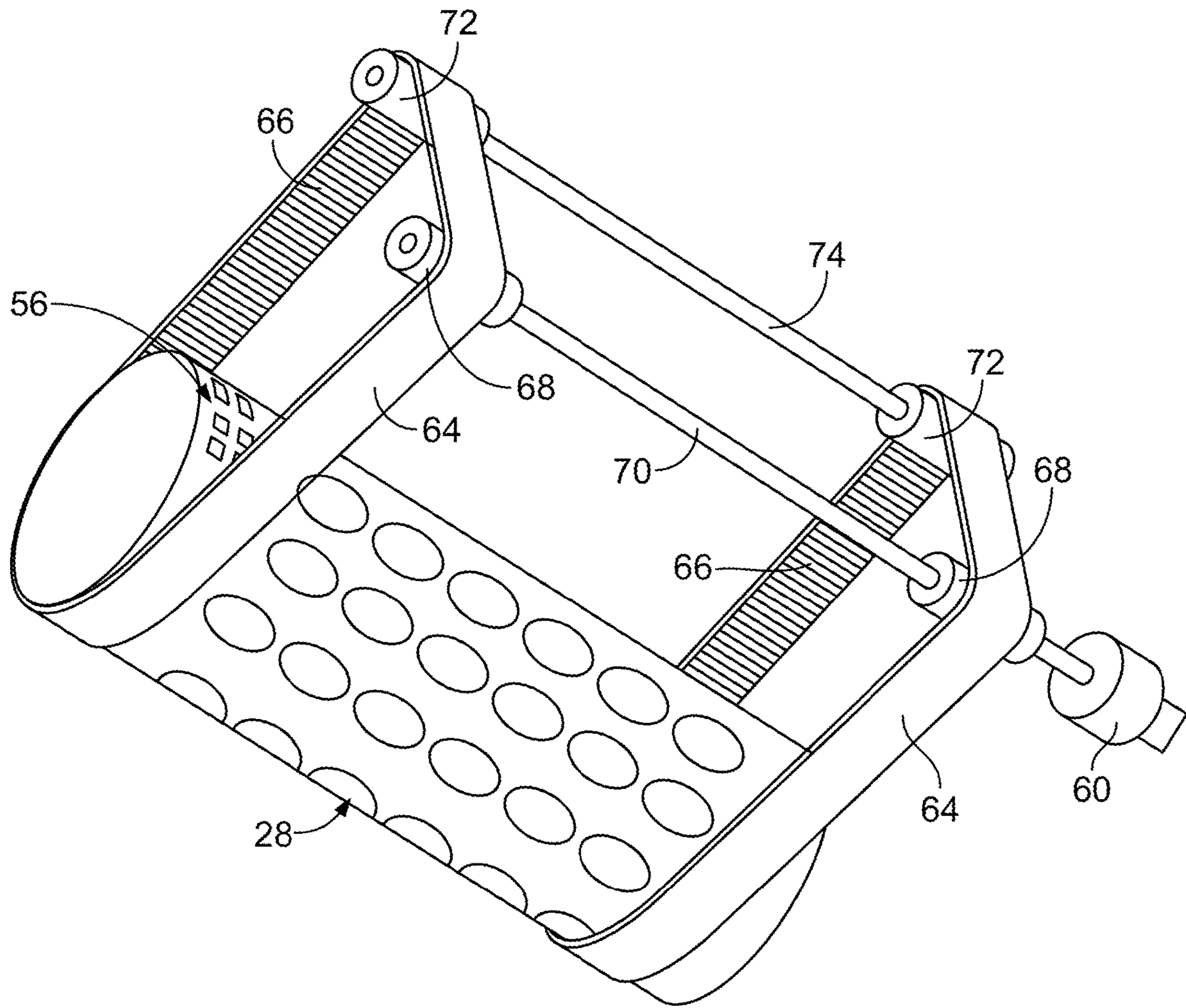


FIG. 6



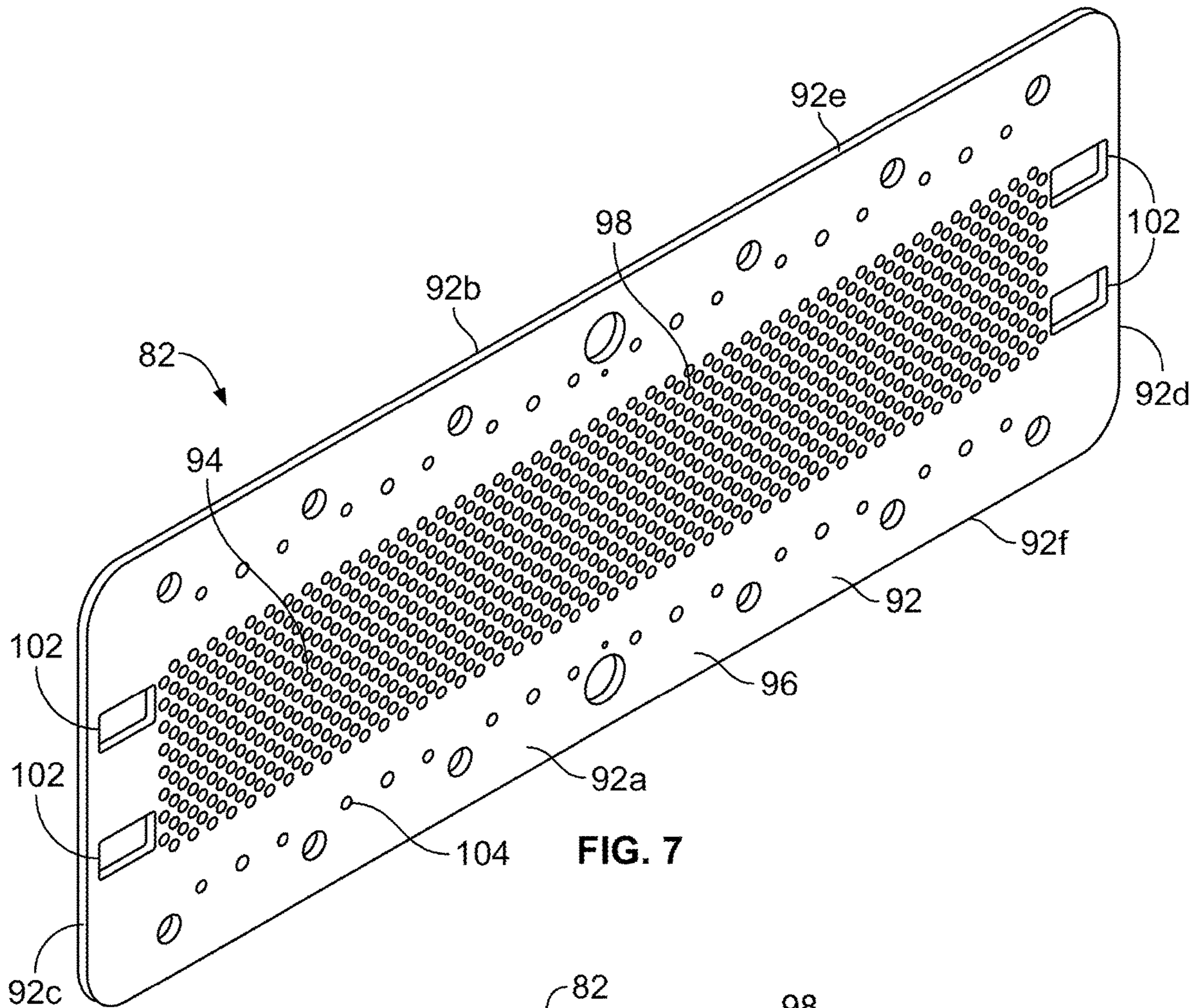


FIG. 7

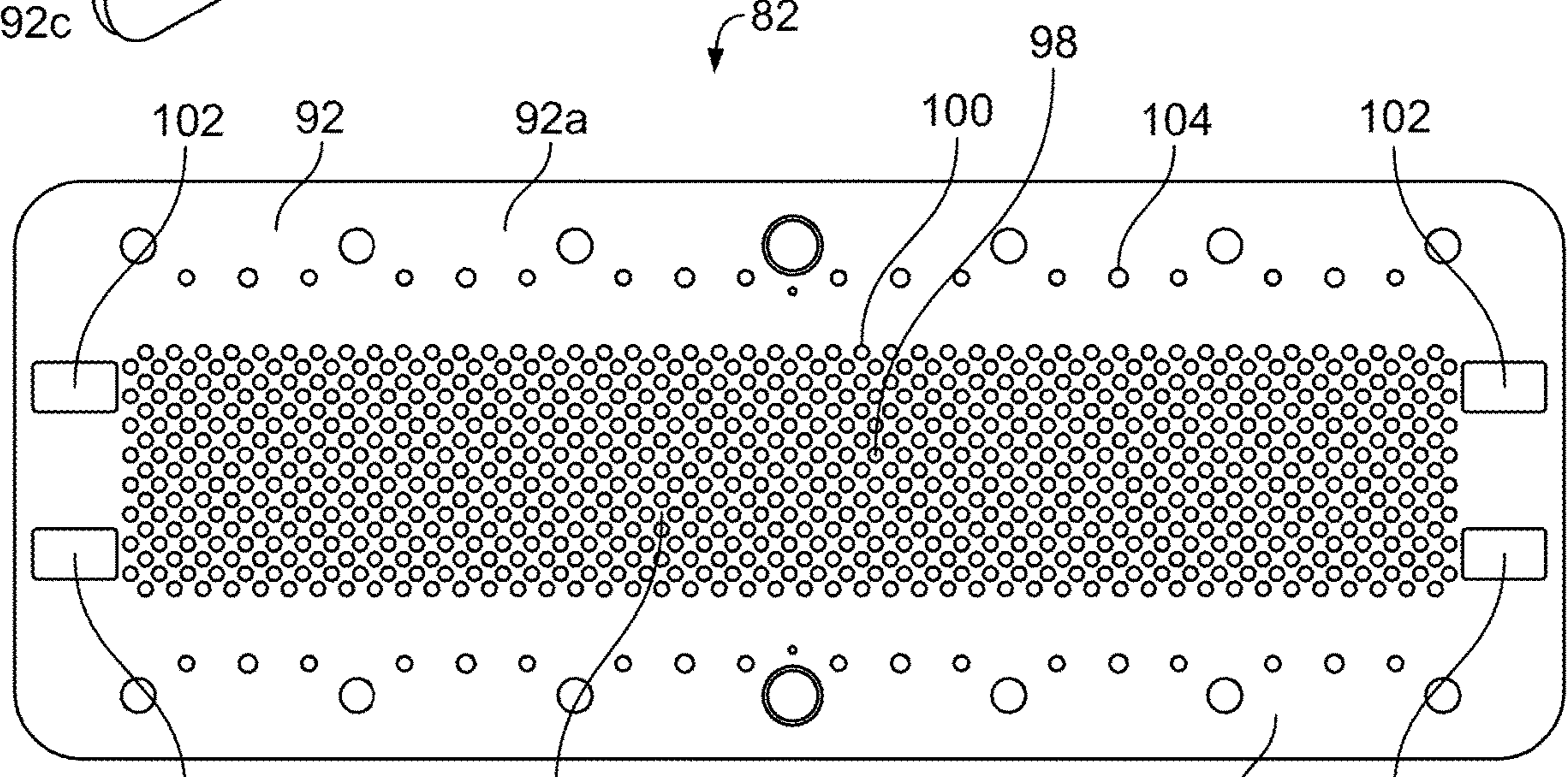


FIG. 8

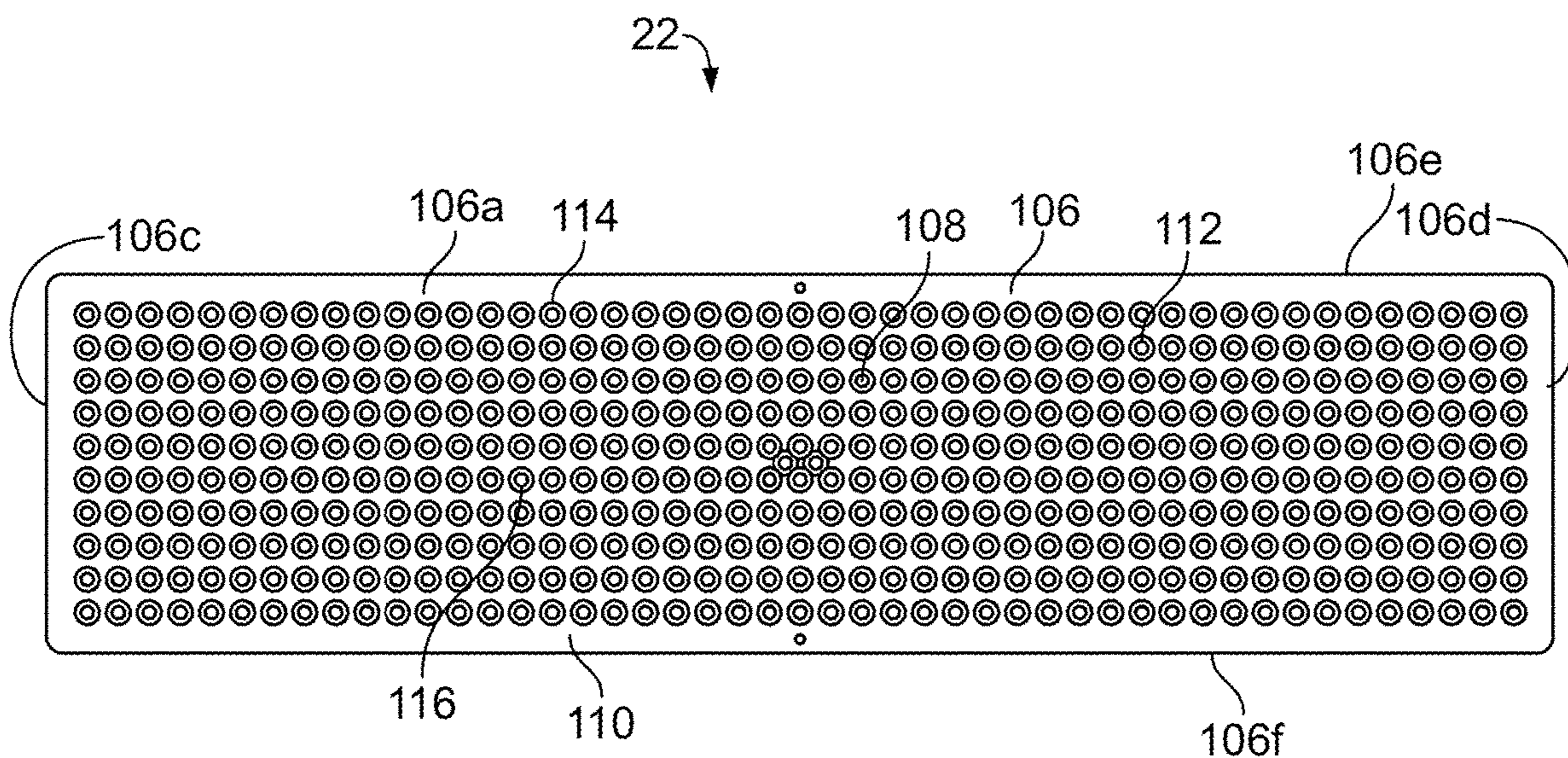


FIG. 9

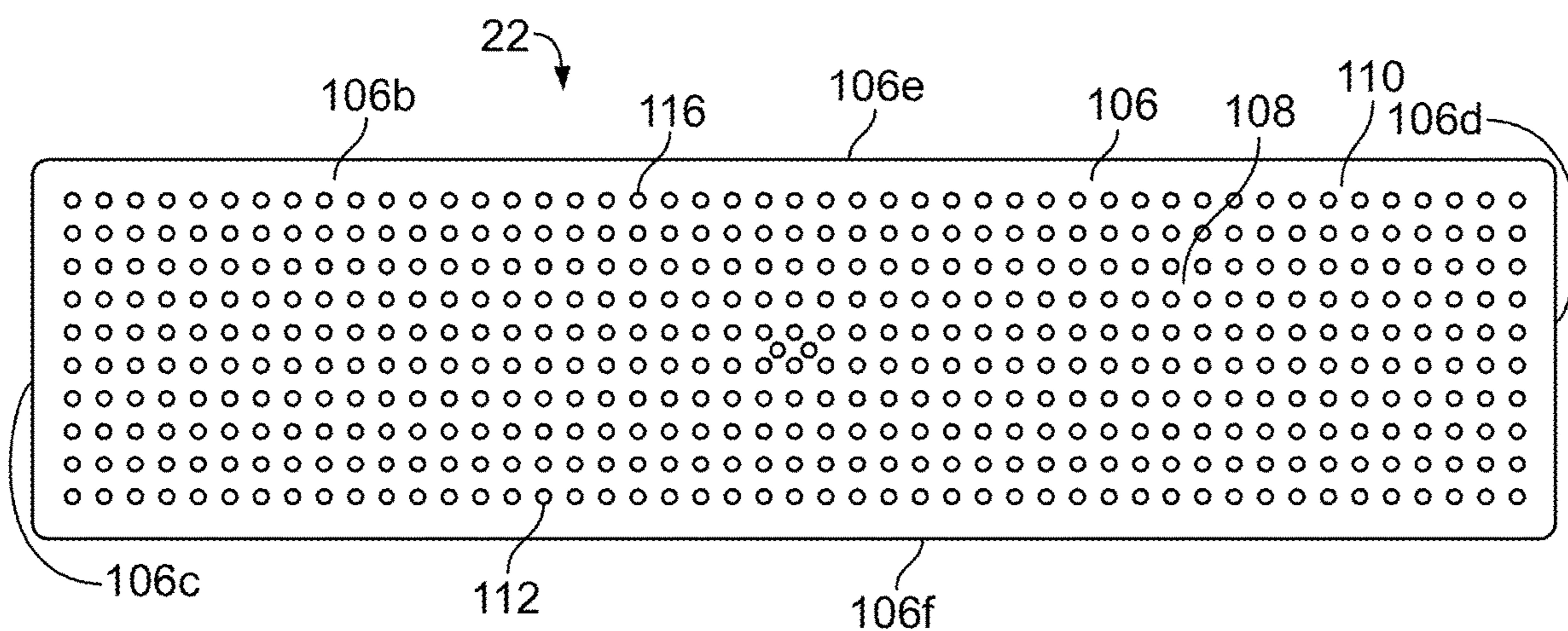


FIG. 10

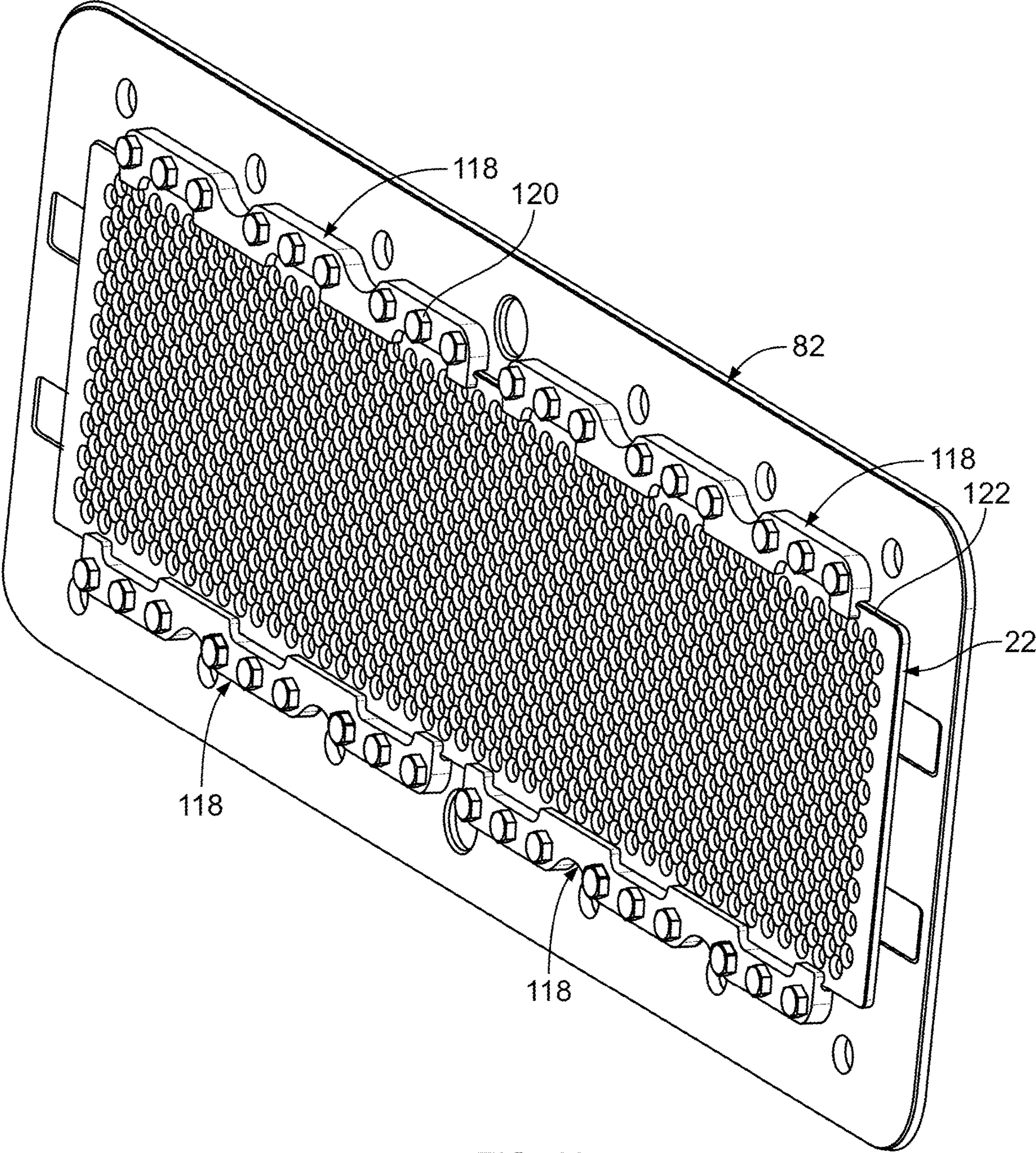


FIG. 11

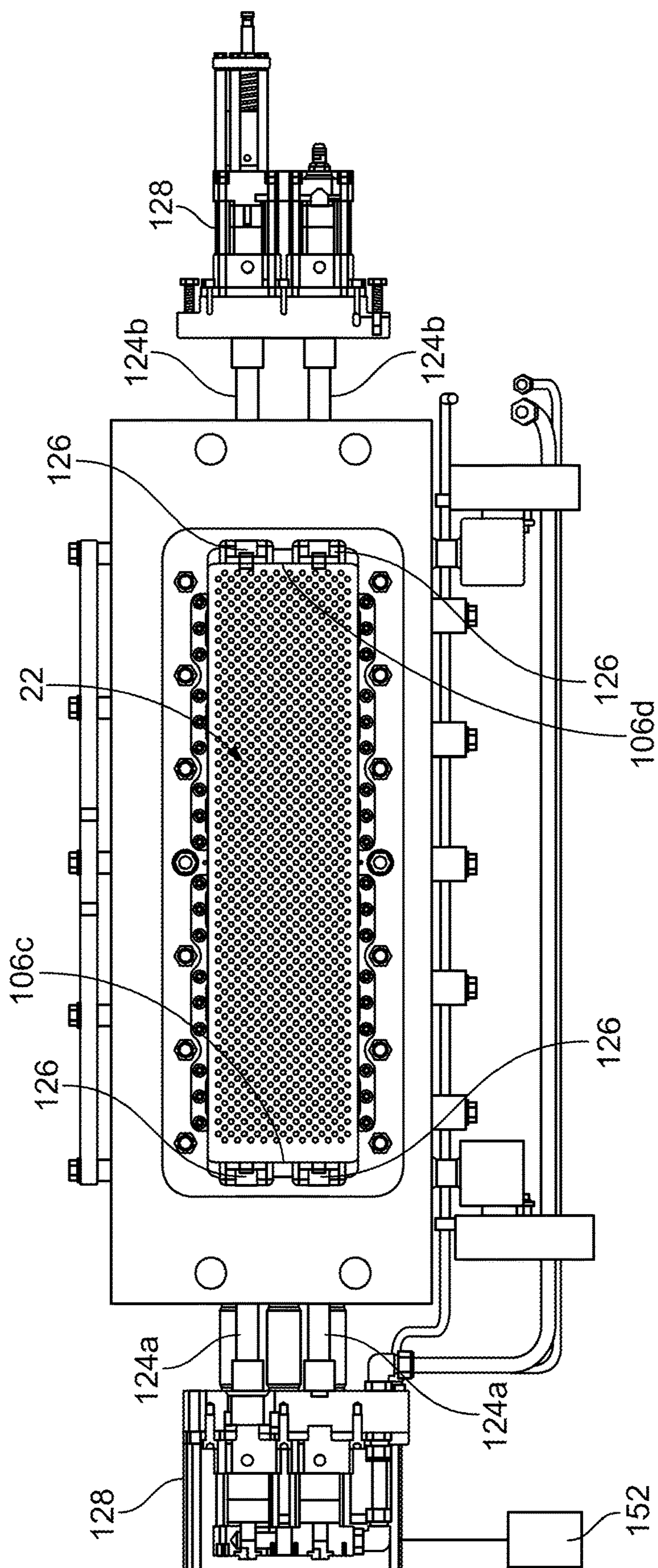


FIG. 12

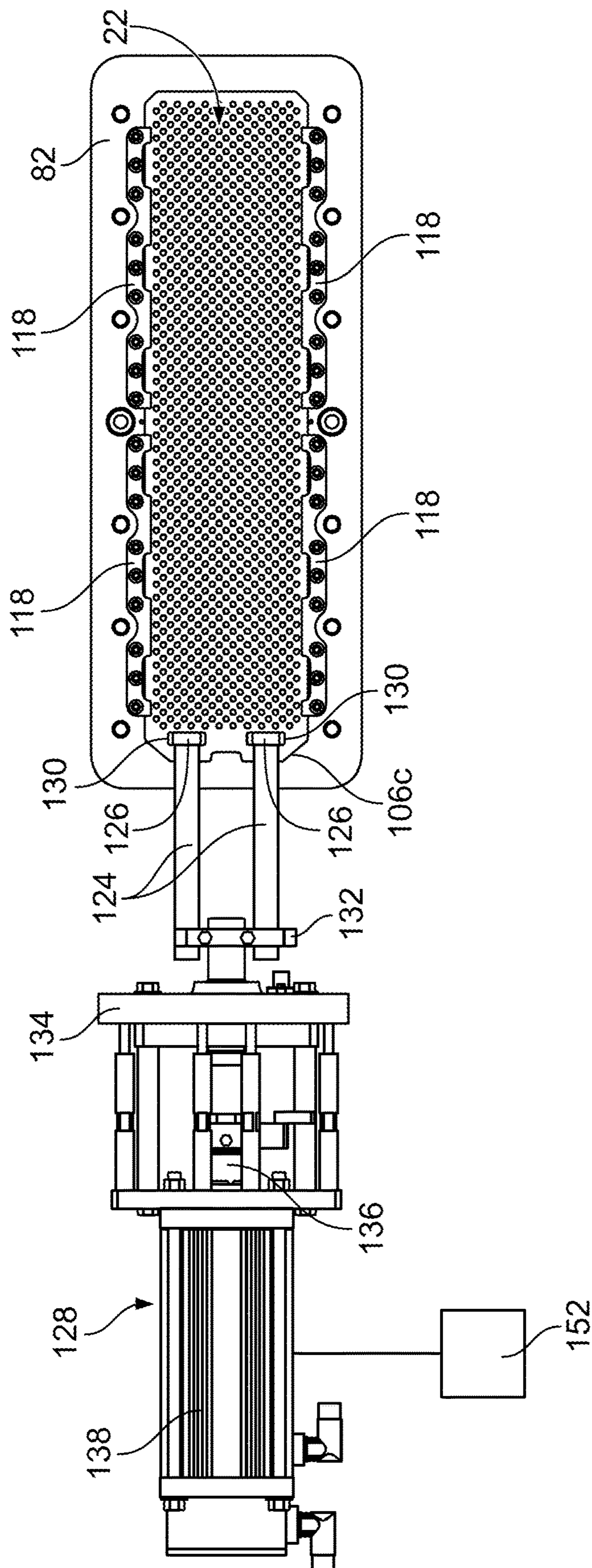


FIG. 13

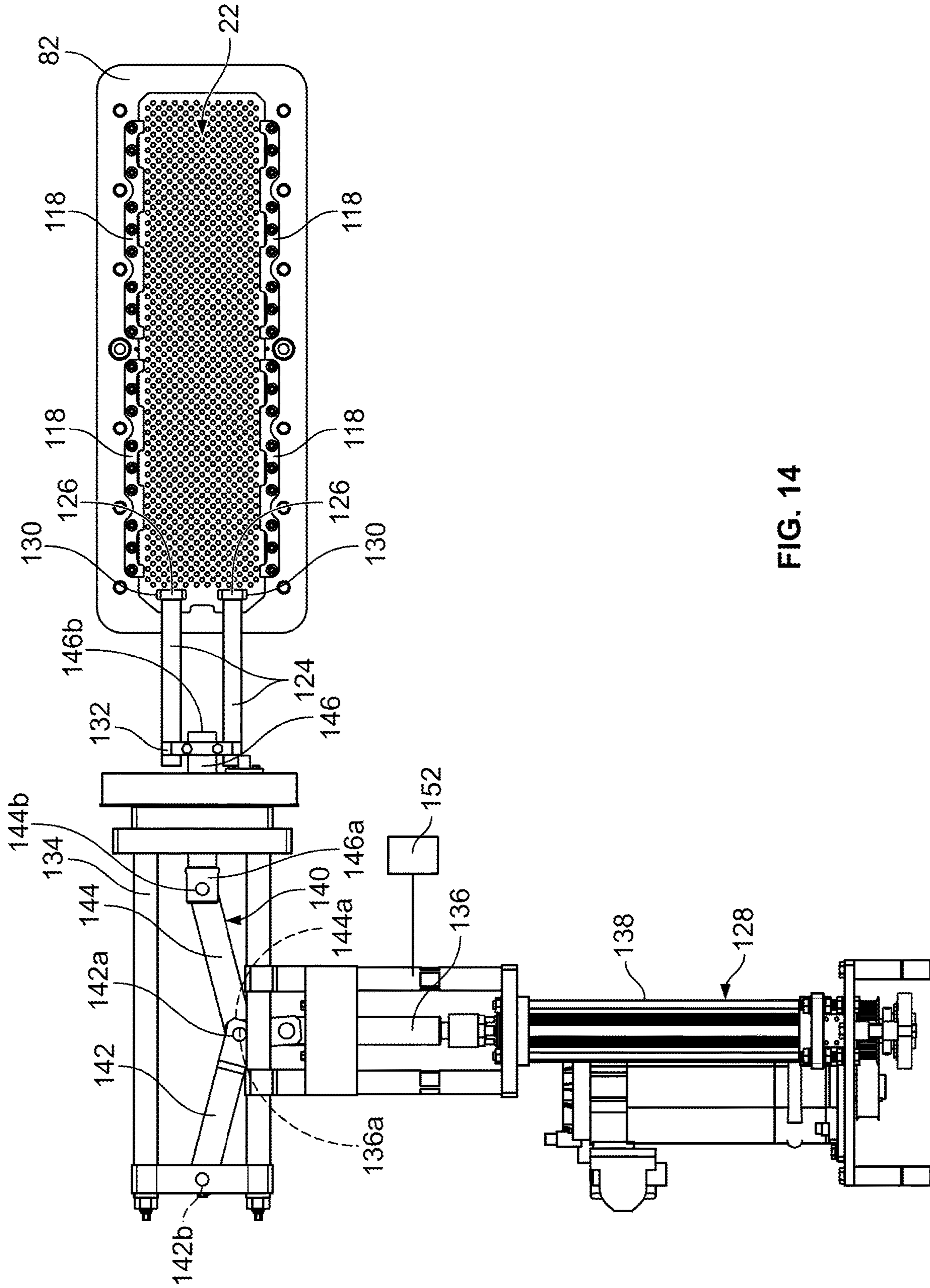


FIG. 14

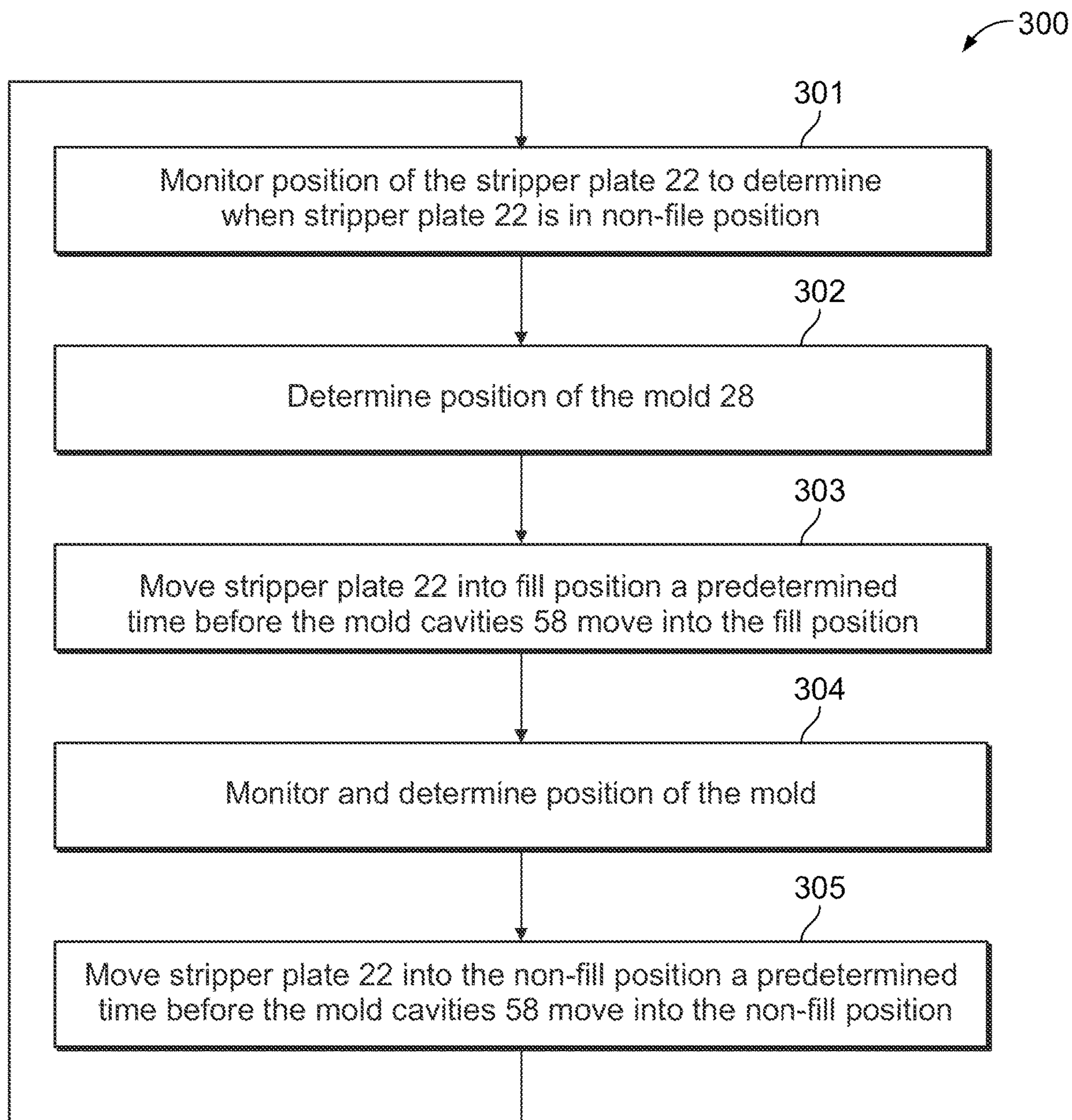


FIG. 15

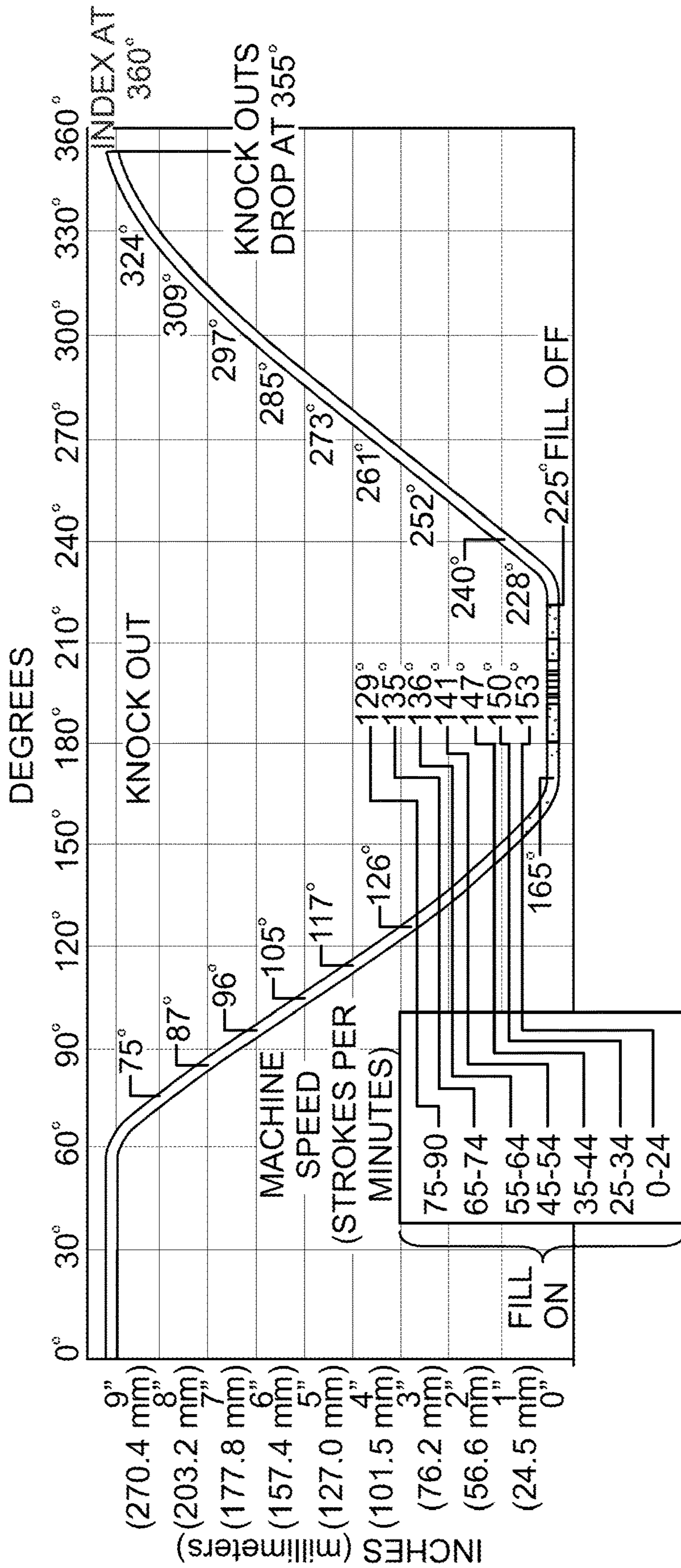


FIG. 16



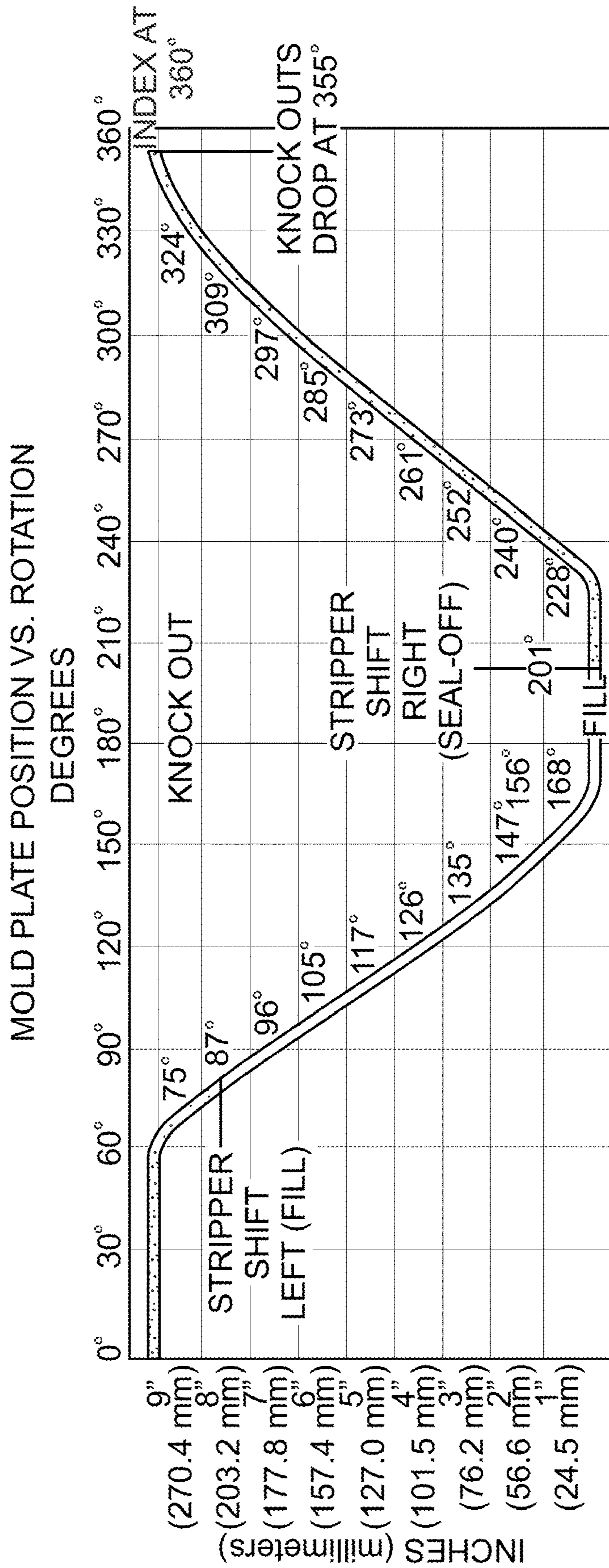


FIG. 17

## SENSOR SYSTEM FOR PATTY FORMING MACHINE AND METHOD OF USE

### CROSS-REFERENCE TO RELATED APPLICATION(S)

This application is a divisional application of U.S. patent application Ser. No. 16/351,826 filed on Mar. 13, 2019, and claims the priority of U.S. provisional application Ser. No. 62/643,903, filed on Mar. 16, 2018, the contents of which are incorporated herein in their entirety.

### FIELD OF THE DISCLOSURE

The present disclosure relates to a control system for a patty molding machine configured for use forming patties.

### BACKGROUND

Food patties of various kinds, including hamburgers, molded steaks, fish cakes, chicken patties, pork patties, potato patties, and others, are frequently formed in high-volume automated molding machines. U.S. Pat. No. 8,469,697 discloses an example of a rotary molding system for molding food products.

### SUMMARY

In an embodiment, a method of using a patty forming machine includes: feeding food product into a pump box, through a stripper plate and through a fill plate when the stripper plate is in a fill position; feeding the food product into mold cavities of a mold when the mold cavities are in a fill position; continuously moving the mold from the fill position to an eject position; sensing a position of the stripper plate; sensing a position of the mold; comparing the positions of the stripper plate and the mold; and moving the stripper plate relative to the pump box and the fill plate from the fill position to a non-fill position when a predetermined position of the mold is determined.

In an embodiment, a method of using a patty forming machine includes: providing a pump box into which food product be fed; providing a stripper plate and a fill plate through which food product can be feed when the stripper plate is in a fill position; providing a mold having mold cavities into which food product can be fed when the mold cavities are in a fill position; continuously moving a mold from a fill position to an eject position; sensing a position of the stripper plate; sensing a position of the mold; comparing the positions of the stripper plate and the mold; and moving the stripper plate relative to the pump box and the fill plate from the fill position to a non-fill position when a predetermined position of the mold is determined.

In an embodiment, a patty forming machine includes a pump box configured to receive food product therein; a fill plate having a plurality of holes therethrough through which food product is configured to pass; a stripper plate having a plurality of holes therethrough through which food product is configured to pass when the stripper plate is in a fill position, the stripper plate being positioned between the pump box and the fill plate, the stripper plate being movable in a reciprocating manner relative to the fill plate and the pump box from the fill position to a non-fill position; a stripper plate sensor operatively coupled to the stripper plate, the stripper plate sensor configured to determine positions of the stripper plate; a mold comprising a wall having a plurality of mold cavities; a motor coupled to the

mold and configured to continuously move the mold relative to the fill plate; a mold sensor operatively coupled to the mold, the mold sensor configured to determine positions of the mold; and a controller, having a processor and memory architecture, configured to: compare the positions of the stripper plate and the mold based upon information received from the stripper plate sensor and with the mold sensor; and send a signal to move the stripper plate relative to the pump box and the fill plate from the non-fill position to the fill position when a predetermined position of the mold is determined.

### BRIEF DESCRIPTION OF THE DRAWINGS

The organization and manner of the structure and operation of the disclosed embodiments, together with further objects and advantages thereof, may best be understood by reference to the following description, taken in connection with the accompanying drawings, which are not necessarily drawn to scale, wherein like reference numerals identify like elements in which:

FIG. 1 depicts a side elevation view of an embodiment of a patty forming machine in which a rotary molding system is used;

FIG. 2 depicts a block diagram of a control system for a patty forming machine such as that shown in FIG. 1;

FIG. 3 depicts an exploded perspective view of the rotary molding system;

FIG. 4 depicts an alternate exploded perspective view of the rotary molding system;

FIG. 5 depicts a perspective view of the rotary molding system;

FIG. 6 depicts a perspective view of a portion of the rotary molding system;

FIG. 7 depicts a perspective view of a wear plate of the rotary molding system;

FIG. 8 depicts a plan view of the wear plate;

FIG. 9 depicts a plan view of a stripper plate of the rotary molding system;

FIG. 10 depicts an alternate plan view of the stripper plate;

FIG. 11 depicts a perspective view of the stripper plate mounted on the wear plate by retainer bars;

FIG. 12 depicts a plan view of a drive mechanism, a coupler, the stripper plate and the wear plate in accordance with an embodiment;

FIG. 13 depicts a plan view of a drive mechanism, a coupler, the stripper plate and the wear plate in accordance with an embodiment;

FIG. 14 depicts a plan view of a drive mechanism, a coupling arrangement, a coupler, the stripper plate and the wear plate in accordance with an embodiment;

FIG. 15 is a flowchart; and

FIGS. 16 and 17 are graphs.

### DETAILED DESCRIPTION

While the disclosure may be susceptible to embodiment in different forms, there is shown in the drawings, and herein will be described in detail, a specific embodiment with the understanding that the present disclosure is to be considered an exemplification of the principles of the disclosure, and is not intended to limit the disclosure to that as illustrated and described herein. Therefore, unless otherwise noted, features disclosed herein may be combined together to form additional combinations that were not otherwise shown for purposes of brevity. It will be further appreciated that in

some embodiments, one or more elements illustrated by way of example in a drawing(s) may be eliminated and/or substituted with alternative elements within the scope of the disclosure.

A control system **20** is provided and is used to control the position of a stripper plate **22** of a molding system **24** in a patty forming machine **26** by using information from the positioning of a mold **28** of the molding system **24**. In an embodiment, the molding system **24** is a rotary molding system wherein the mold **28** rotates around an axis, and FIG. **1** illustrates the primary components of an embodiment of a rotary molding system. While the drawings show the control system **20** used in association with a rotary molding system, the control system **20** can be used in association with a reciprocating or slide plate molding system wherein the mold reciprocates backward and forward as is known in the art.

In general, the patty forming machine **26** includes a feeder portion **30** which supplies food product to the molding system **24**. In an embodiment, the feeder portion **30** is formed from a hopper **32** connected to a pump box **34** by an auger system connected to a pump intake passage, a motor driven rotary pump, and a pump output passage (not shown). Such a feeder portion is disclosed in U.S. Pat. No. 8,469,697, the contents of which are incorporated herein in its entirety by reference, and is not described in detail herein.

As shown in FIGS. **3** and **4**, the pump box **34** may include a housing **36** and an insert **38** inserted within a chamber **40** in the housing **36**. When the housing **36** and insert **38** are connected together, a cavity is formed therebetween. The position of the insert **38** may be adjusted relative to the housing **36** in order to vary the size of the cavity therebetween. The housing **36** has at least one feed opening **42** and the insert **38** has at least one feed opening **44** to channel food product from the hopper **32** through the pump box **34**. The feed openings **42**, **44** may be aligned. In an embodiment, the pump box **34** is formed of a single component.

The molding system **24** includes a stationary support structure **46** which is attached to a cabinet **48** of the patty forming machine **26**, the mold **28** mounted on the support structure **46** by an inner platen **50** (see FIG. **3**), and a food channel assembly **52** which directs food product from the pump box **34** to the mold **28**. In a rotary molding system, the mold **28** is rotatably mounted on the support structure **46**. In a reciprocating molding system, the mold **28** is reciprocally mounted on the support structure **46**.

In an embodiment, the support structure **46** is cantilevered from the cabinet **48**. The support structure **46** may be formed of steel. Alternatively, the support structure **46** can be supported on both ends. In an embodiment, the support structure **46** is a mandrel.

The mold **28** is formed of a cylindrical wall **54**, and a toothed gear ring **56** extending about the circumference of the wall **54** at each end thereof. A plurality of spaced apart mold cavities **58** are provided through the wall **54** and are disposed around the circumference of the wall **54**. In an embodiment, the mold cavities **58** are provided in an array of rows and columns such that each mold cavity **58** in a given row commences at the same position of the mold **28** and such that each mold cavity **58** in a given row terminates at the same position of the mold **28**. The wall **54** has a thickness which corresponds to the depth of the mold cavities **58**. The number of mold cavities **58** around the circumference of the wall **54** can vary. In addition, the shape of the mold cavities **58** can vary. A motor **60** and associated structure **62** for moving the mold **28** relative to the support structure **46** is provided. Structures **62** for rotating the mold

**28** are disclosed in U.S. Pat. No. 8,469,697, the contents of which have been incorporated herein.

In some embodiments, the motor **60** is a servomotor or stepper motor. In some embodiments, the motor **60** is a gear motor, a brushless DC servo motor, a Permanent Magnet DC (PMDC) motor an AC induction motor with modulated control signal and switches to control speed and direction of rotation, some combination thereof, or the like.

As an example, the structure **62** for rotating the mold **28** is provided by toothed endless belts **64** connected to the motor **60** as illustrated in FIG. **6**. The toothed gear ring **56** engages with a toothed surface **66** of the toothed endless belt **64**. Each toothed endless belt **64** is driven by rollers **68** which are connected via a common shaft **70**. The motor **60** drives the rollers **68**. The toothed endless belts **64** are further supported by idler support rollers **72** connected via a common shaft **74**. The rollers **68**, **72** can optionally comprise a toothed ring. In an alternative embodiment, the idler support rollers **72** and their common shaft **74** can be removed depending on the desired configuration, such that the toothed endless belts **64** only wrap around one set of rollers **68**.

As shown in FIGS. **3** and **4**, the inner platen **50** is formed from a body **76** having a mold facing surface and an opposite support structure engaging surface. The mold facing surface is curved in accordance with the radius of curvature of the cylindrical mold **28**. The support structure engaging surface may be curved. The inner platen **50** may be formed of plastic. The body **76** has perforations **78** therethrough which provides an air management system for allowing air to escape the mold cavities **58** as food product fills the mold cavities **58** and displaces the air in the mold cavities **58**. The perforations **78** may take the form of an array of a plurality of distinct holes which form rows and columns. The inner platen **50** is affixed to the support structure **46** by suitable means such as fasteners, and is attached to the mold **28** such that the mold **28** can rotate around the inner platen **50** and the support structure **46**.

The food channel assembly **52**, see FIGS. **3** and **4**, includes a fill plate **80** which is proximate to the mold **28**, a wear plate **82** fixedly attached to the fill plate **80**, and the stripper plate **22** movably attached to the wear plate **82**. The stripper plate **22** moves in a reciprocating manner relative to the wear plate **82**. The food channel assembly **52** is attached to the housing **36** of the pump box **34**. In an embodiment, the fill plate **80** is formed of two parts, with an inner perforated body **84** which seats within an outer platen **86**. The body **84** is formed of metal. The outer platen **86**, if provided, is formed of plastic.

The inner perforated body **84** has holes **88** therethrough. An inlet surface of the body **84** is planar. An outlet surface of the body **84** may be planar or may be curved in accordance with the radius of curvature of the mold **28**. The holes **88** may take the form of an array of a plurality of distinct holes which form rows and columns. The outlet surface of the body **84** is in in close proximity to, but spaced from, the outer surface of the mold **28**. A sealing mechanism or layer (not shown) may be disposed on outlet surface of the body **84** to ensure adequate close contact with the mold **28** and to prevent food product from leaking from the mold cavities **58** once the mold cavities **58** are filled.

When the body **84**, the mold **28** and the inner platen **50** are assembled together, the perforations **78** in the inner platen **50** are offset from the holes **88** in the body **84**. The body **84** has substantially more holes **88** than the number of perforations **78** in the inner platen **50**.

## 5

In an embodiment, the body **84** is mounted in the outer platen **86** which forms a frame for the body **84**. A passageway **90** is provided through the outer platen **86** and extends from an inlet surface of the outer platen **86** to an outlet surface of the outer platen **86**. The body **84** seats within the passageway **90**. In an embodiment, the outer platen **86** is sandwiched between the pump box **34** and the mold **28**, and is free floating relative to the pump box **34** and mold **28**. In an embodiment, the outer platen **86** is affixed to the housing **36** of the pump box **34** by suitable means such as bolts, and is spaced from the mold **28**.

As shown in FIGS. 7 and 8, the wear plate **82** is formed from a body **92** having a first surface **92a** and a second surface **92b** defined by parallel side edges **92c**, **92d** and parallel end edges **92e**, **92f**. The wear plate **82** is formed of metal. The first and second surfaces **92a**, **92b** are planar. A length of the wear plate **82** is defined between the side edges **92c**, **92d**. The body **92** has a central perforated portion **94** with a non-perforated portion **96** extending around the perimeter of the central perforated portion **94** and between the central perforated portion **94** and the edges **92c**, **92d**, **92e**, **92f**. An array of a plurality of distinct holes **98** are provided through the central perforated portion **94** of the body **92**. The walls **100** forming the holes **98** are straight from the first surface **92a** to the second surface **92b**, that is each hole **98** has a uniform diameter along its length from the first surface **92a** to the second surface **92b**. The central axis of each hole **98** is parallel to each other. In an embodiment, the holes **98** in the wear plate **82** have the same diameter as the holes **88** in the body **84**. The wear plate **82** has two pairs of recesses **102** in each surface **92a**, **92b** in the non-perforated portion **96** proximate to, but spaced from, the side edges **92c**, **92d**. When the wear plate **82** is assembled with the body **84**, the holes **98** in the wear plate **82** are aligned with the holes **88** in the body **84**. The wear plate **82** has a plurality of apertures **104** through the non-perforated portion **96** proximate to, but spaced from, the end edges **92e**, **92f**.

The wear plate **82** can be assembled with the body **84** with either the first surface **92a** abutting against the body **84** or with the second surface **92b** abutting against the body **84** as the wear plate **82** is identically formed on both surfaces **92a**, **92b**.

The stripper plate **22** is disposed between the wear plate **82** and the pump box **34** and is capable of reciprocal movement relative to the wear plate **82** and the pump box **34**. The stripper plate **22** is formed of metal. As shown in FIGS. 9 and 10, the stripper plate **22** is formed from a body **106** having an inlet surface **106a** and an outlet surface **106b** defined by parallel side edges **106c**, **106d** and parallel end edges **106e**, **106f**. The inlet and outlet surfaces **106a**, **106b** are planar. A length of the stripper plate **22** is defined between the side edges **106c**, **106d**. The body **106** has a central perforated portion **108** with a non-perforated portion **110** extending around the perimeter of the central perforated portion **108** and between the central perforated portion **108** and the edges **106c**, **106d**, **106e**, **106f**. An array of a plurality of distinct holes **112** are provided through the central perforated portion **108** of the body. Each hole **112** in the array may be straight as it extends from the inlet surface **106a** to the outlet surface **106b** such that it has a uniform diameter along its length. Each of the holes **112** in the array or predetermined ones of the holes **112** in the array may have a tapered or frustoconical wall **114** extending from the inlet surface **106a** and a straight wall **116** extending from the outlet end of the tapered or frustoconical wall **114** to the outlet surface **106b**. The tapered or frustoconical wall **114**

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has its greatest diameter at its inlet end which is at the inlet surface **106a** of the stripper plate **22** and has its smallest diameter at its outlet end which is at the junction of the tapered or frustoconical wall **114** and the straight wall **116**. The tapered or frustoconical wall **114** has a continuously reducing diameter as it extends along its length from its inlet end to the outlet end. The straight wall **116** has a uniform diameter along its length. The holes **112** may be a combination of both types. In an embodiment, the holes **112** in the stripper plate **22** are aligned in rows and columns. In an embodiment, the holes **112** in the stripper plate **22** have the same diameter as the holes **88** in the body **84**.

The holes **112** in the stripper plate **22** are aligned in rows and columns and when assembled with the wear plate **82** and in the fill plate **80**, the holes **112** in the stripper plate **22** are aligned with the holes **98** in the wear plate **82** and the holes **88** in the body **84** when in a fill position, and when the stripper plate **22** is shifted, the holes **112** in the stripper plate **22** are offset from the holes **98** in the wear plate **82** and in the holes **88** in the body **84** when in a non-fill position.

As shown in FIG. 11, the stripper plate **22** is connected to the wear plate **82** by retainer bars **118** attached to the wear plate **82**, for example by fasteners **120**. Each retainer bar **118** has a recess **122** machined therein into which the stripper plate **22** seats.

The stripper plate **22** and the wear plate **82** seat within the pump box **34**. The stripper plate **22** is proximate to the feed openings **42**, **44** in the pump box **34**. The planar inlet surface of the body **84** which forms the fill plate **80** seats against the first or second surface **92a**, **92b** of the wear plate **82** (depending upon which way the wear plate **82** is used). Thereafter, fasteners, such as bolts, are passed through the pump box **34**, through the wear plate **82** and through the fill plate **80** to connect the pump box **34**, the stripper plate **22**, the wear plate **82** and the fill plate **80** together.

As disclosed in U.S. Pat. No. 8,469,697, the contents of which have been incorporated herein, in an embodiment, two sets of rods **124a**, **124b**, see FIG. 12, have disk shaped heads **126** that are in contact with the side edges **106c**, **106d** of the stripper plate **22**. The rods **124a**, **124b** extend through the side walls of the pump box housing **36** and are connected to respective first and second drive mechanisms **128**, such as hydraulic cylinders or motors. In some embodiments, the motors are servomotors or stepper motors. In some embodiments, the drive mechanisms **128** may include an on-board motor controller, which may control operation of the drive mechanisms **128**, and which may form part of and/or interface with the control system **20** illustrated in and described with respect to FIG. 2. The drive mechanisms **128** may be indirectly interfaced via and controlled by control circuitry, such as may be provided by the control system **20**.

To move the stripper plate **22** relative to the wear plate **82** and the fill plate **80**, the first drive mechanism **128** is activated to extend the rods **124a** and move the stripper plate **22** in a first direction thereby causing the rods **124b** to retract within the second drive mechanism **128**, and thereafter the second drive mechanism **128** is activated to extend the rods **124b** and move the stripper plate **22** in a second, opposite direction thereby causing the rods **124a** to retract within the first drive mechanism **128**. This is repeated to cause the stripper plate **22** to slide back and forth across the wear plate **82** in a reciprocating manner. The heads **126** of the rods **124a**, **124b** seat within the recesses **102** of the wear plate **82** to abut against the side edges **106c**, **106d** of the stripper plate **22**. The reciprocating motion severs any residual food product fibers which may be caught in the holes **98** of the wear plate **82** after each time the food product is passed

through the holes 98 of the wear plate 82. The recesses 122 provide a running clearance to allow the stripper plate 22 to shift relative to the wear plate 82.

As shown in FIG. 13, the stripper plate 22 has been modified to include a pair of recesses or apertures 130 into which the heads 126 of the rods 124 are seated. A pair of spaced apart apertures 130 are provided on surface 106a and on the same side of the stripper plate 22, for example, proximate to edge 106c. Alternatively, recesses may be provided on each surface of the stripper plate 22. Rods 124 extend through the same side wall of the pump box housing 36 and are connected to a single drive mechanism 128, such as an electric actuator or a hydraulic cylinder, by a coupler 132. The drive mechanism 128 is mounted on a stationary frame 134 connected to the pump box housing 36. The drive mechanism 128 includes a piston 136 which can be extended from a cylinder 138 or can be retracted into the cylinder 138. The piston 136 is coupled to the rods 124 by the coupler 132. In this embodiment, the piston 136 of the drive mechanism 128 is linearly aligned with the rods 124. To move the stripper plate 22 relative to the wear plate 82, the drive mechanism 128 is activated to extend the piston 136 from the cylinder 138, thereby moving the rods 124 and the stripper plate 22 in a first direction relative to the wear plate 82, and thereafter the drive mechanism 128 is activated to retract the piston 136 into the cylinder 138, thereby moving the rods 124 and the stripper plate 22 in a second, opposite direction relative to the wear plate 82. This is repeated to cause the stripper plate 22 to slide back and forth across the wear plate 82 in a reciprocating manner to sever any residual food product fibers which may be caught in the holes 98 of the wear plate 82 after each time the food product is passed through the holes 98 of the wear plate 82. The recesses 102 in the wear plate 82 may be eliminated as recesses 102 are not used in this embodiment.

As shown in FIG. 14, the modified stripper plate 22 and the drive mechanism 128 are used and the specifics are not repeated. The rods 124 extend through a side wall of the pump box housing 36 and are connected to the single drive mechanism 128 by a coupling arrangement 140. In this embodiment, the piston 136 of the drive mechanism 128 is not linearly aligned with the rods 124, and instead is perpendicular to the rods 124 as a result of the coupling arrangement 140. In this embodiment, the coupling arrangement 140 includes a first link 142 having a first end 142a pivotally attached to the end 136a of the piston 136 and second end 142b pivotally attached to a stationary frame 134 connected to the pump box housing 36, a second link 144 having a first end 144a pivotally attached to the end 136a of the piston 136 and second end 144b pivotally attached to a first end 146a of a rod 146, the rod 146 extending through the stationary frame 134. The rod 146 and the second end 142b of the first link 142 may be linearly aligned. A second end 146b of the rod 146 is coupled to the rods 124 by the coupler 132. To move the stripper plate 22 relative to the wear plate 82, the drive mechanism 128 is activated to move the rods 124 and the stripper plate 22 in a first direction relative to the wear plate 82, and thereafter the drive mechanism 128 is activated to move the rods 124 and the stripper plate 22 in a second, opposite direction relative to the wear plate 82. When the piston 136 is extended from the cylinder 138, the first ends 142a, 144a of the first and second links 142 move away from the cylinder 138 which causes the rod 146 to translate in a direction perpendicular to the piston 136 and toward the wear plate 82. This movement of the rod 146 causes movement of the rods 124 and then movement of the stripper plate 22 in the first direction. When the piston

136 is retracted into the cylinder 138, the first ends 142a, 144a of the first and second links 142 move toward the cylinder 138 which causes the rod 146 to translate in a direction perpendicular to the piston 136 and away from the wear plate 82. This movement of the rod 146 causes movement of the rods 124 and then movement of the stripper plate 22 in the second, opposite direction. This is repeated to cause the stripper plate 22 to slide back and forth across the wear plate 82 in a reciprocating manner to sever any residual food product fibers which may be caught in the holes 98 of the wear plate 82 after each time the food product is passed through the holes 98 of the wear plate 82. The recesses 102 in the wear plate 82 may be eliminated as recesses 102 are not used in this embodiment.

In some embodiments, motors used for the drive mechanisms 128 are gear motors, brushless DC servo motors, Permanent Magnet DC (PMDC) motors, AC induction motors with modulated control signal and switches to control speed and direction of rotation or reciprocation, some combination thereof, or the like. In some embodiments, the motors used for the drive mechanisms 128 may include an on-board motor controller, which may control operation of the motors, and which may form part of and/or interface with the control system 20 illustrated in and described with respect to FIG. 2. The motors used for the drive mechanisms 128 may be indirectly interfaced via and controlled by control circuitry, such as may be provided by the control system 20.

The molding system 24 may include a knock-out mechanism 148 which is known in the art. Such a knock-out mechanism is disclosed in U.S. Pat. No. 8,469,697, the contents of which have been incorporated herein, and is not described in detail herein.

In operation, as the mold 28 moves, each row of mold cavities 58 move into a fill position during which the mold cavities 58 in that given row move past the holes 88 in the fill plate 80. Food product is pumped from the hopper 32 to the molding system 24 by the feeder portion 30. Food product passes through feed openings 42, 44 in the pump box 34, through the holes 112 in the stripper plate 22, through the holes 98 in the wear plate 82, and through the holes 88 in the body 84 to fill the mold cavities 58 in the mold 28. As the mold cavities 58 in the given row are filled during the movement, the mold cavities 58 are moved from the fill position to an eject position where the knock-out mechanism 148 is activated.

As the mold 28 moves into the fill position, the mold cavities 58 in the mold 28 become disposed between the fill plate body 84 and the inner platen 50, with the mold facing surface of the inner platen 50 serving as the bottom surface of the mold cavities 58 as the mold cavities 58 move through the region where it is in contact with the fill plate body 84 and the inner platen 50. In a rotary molding system, the inner platen 50 remains stationary as the mold 28 rotates past the inner platen 50. The support structure 46 behind the inner platen 50 provides support for the inner platen 50 as pressure from filling the mold cavities 58 is exerted into the mold cavities 58 during the filling process. As the mold 28 moves into the eject position, the mold cavities 58 in the mold 28 are no longer disposed between the fill plate body 84 and the inner platen 50.

During operation, the stripper plate 22 shifts relative to the wear plate 82 and the fill plate 80 from the fill position to the non-fill position, then back to the fill position and then to the non-fill position and so on, as controlled by the control system 20 as described herein. When the stripper plate 22 is in the fill position, food product can flow therethrough to fill

the mold cavities **58** of the mold **28**, but when the stripper plate **22** is moved to be in the non-fill position to sever the food product, food product cannot flow therethrough. When the stripper plate **22** is in the non-fill position, the mold **28** is indexed to move the next set of mold cavities **58** into the fill position.

Information relating to the position of the mold **28** and the position of the stripper plate **22** is sent to the control system **20**. The control system **20** processes this information and controls movement of the stripper plate **22** in response.

A variety of means can be provided for providing positional information of the mold **28** and of the stripper plate **22**. In an embodiment having the drive mechanism(s) **128** as hydraulic cylinders, a sensor **150** which senses the position of the mold **28** is provided, and a sensor **152** which senses the position of the stripper plate **22** is provided. The sensors **150**, **152** send information regarding the position of the mold **28** and the stripper plate **22** to the control system **20**. In an embodiment having the drive mechanism(s) **128** as hydraulic cylinders and a servo motor is provided for driving the mold **28**, a sensor **152** which senses the position of the stripper plate **22** is provided, and a potentiometer, encoder, resolver or similar device of the servo motor provides positional feedback and acts as the sensor **150**. In an embodiment having a servo motor provided as the drive mechanism(s) **128** and a servo motor is provided for driving the mold **28**, a potentiometer, encoder, resolver or similar device of the servo motor provides positional feedback of the stripper plate **22** and acts as the sensor **152**, and a potentiometer, encoder, resolver or similar device of the servo motor provides positional feedback of the mold **28** and acts as the sensor **150**. In some embodiments, the sensors **150**, **152** are position sensors and/or proximity sensors. Other known sensors may be used.

The control system **20** may include a non-transitory memory **154** and a processor **156** configured to process information received from the sensors **150**, **152**. While illustrated as a single memory **154**, it will be appreciated that in some example embodiments, the memory **154** may include multiple individual memory devices collectively providing functionality of the memory **154**, which may be distributed across one or more computing devices that may provide functionality of the control system **20**. In some example embodiments, the memory **154** may include non-transitory memory. The processor **156** is configured to control operation (e.g., movement) of the stripper plate **22** based at least in part on data stored in memory **154**. The data may include information regarding the rotational position of the mold cavities **58** of the mold **28** or the position of the mold cavities during the reciprocating movement of the mold. While illustrated as a single processor **156**, it will be appreciated that in some embodiments, the processor **156** may include multiple processors collectively configured to provide functionality of the processor **156** and which may be distributed across one or more computing devices that may provide functionality of the control system **20**. An example processor **156** includes, but is not limited to, a programmable logic controller (PLC) manufactured by Horner APG, LLC, model number XL7 (RE-W1E2).

The control system **20** is configured to control the drive mechanism **128** and thus the movement of the stripper plate **22**. In some embodiments, the drive mechanism **128** includes interfaces, such as CAN bus interfaces configured to receive control signals from the control system **20**. Other types of communication interfaces can be used to send control signals to the drive mechanism **128**.

The positions of the mold cavities **58** is programmed into the memory **154**. The processor **156** receives positional information from the sensor **152** on the drive mechanism **128** and the sensor **150** on the mold **28** and processes this information. The processor **156** determines when to move the stripper plate **22** and sends a signal to the drive mechanism **128** to move the stripper plate **22**. In an embodiment, a signal is sent to the drive mechanism **128** a predetermined time before the mold cavities **58** are moved into the fill position to move the stripper plate **22** to the fill position, and a signal is sent to the drive mechanism **128** a predetermined time before the mold cavities **58** are completely filled to move the stripper plate **22** to the non-fill position. This is continuously repeated as the mold **28** is moved into its fill position and its eject position.

A flowchart showing an embodiment of a method **300** of use is shown in the flowchart of FIG. **15**. In step **301**, the position of the stripper plate **22** is monitored by the processor **156** receiving positional information from the sensor **152** and the processor **156** processes this information to determine when the stripper plate **22** is in the non-fill position. In step **302**, the position of the mold **28** is determined by the processor **156** receiving positional information from the sensor **150** and processes this information to determine the position of the mold **28**. In step **303**, the processor **156** determines when the stripper plate **22** should be moved based upon the position of the mold **28**, and the stripper plate **22** is moved into the fill position a predetermined time before the mold cavities **58** move into the fill position. In step **304**, the position of the mold **28** is monitored by the processor **156** by receiving positional information from the sensor **150** on the mold **28** and processing this information to determine if the mold **28** will be moving to the non-fill position. In step **305**, the stripper plate **22** is moved into the non-fill position a predetermined time before the mold cavities **58** move into the non-fill position. Thereafter, the method **300** proceeds back to step **301**.

It is important to know the position of the stripper plate **22** relative to the position the mold **28** to ensure consistent filling of the food product in the mold cavities **58** of the mold **28**. Changes in temperature of the food product feed into the pump box **34** from one batch of food product to the next batch of food product may cause the stripper plate **22** to move slower or faster through the food product. For example, if a current batch of food product being feed through is colder than the previous batch of food product which was just feed through, the stripper plate **22** will move slower through the food product in the current batch which will delay the full shifting of the stripper plate **22** to prevent the flow of food product therethrough. Likewise, if a current batch of food product being feed through is warmer than the previous batch of food product which was just feed through, the stripper plate **22** will move faster through the food product in the current batch will cause the full shifting of the stripper plate **22** to occur sooner than the previous shift. In another example, food product may become caked onto the stripper plate **22** which causes the movement of the stripper plate **22** to slow down. In yet a further example, the drive mechanism(s) **128** driving the movement of the stripper plate **22** may become worn, which causes the movement of the stripper plate **22** to slow down. A variety of other reasons may occur which throws off the timing of the stripper plate **22** relative to the position of the mold cavities **58**.

FIGS. **15** and **16** show graphs of when the stripper plate **22** is shifted relative to the rotational position of the mold **28** in an example embodiment.

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The control system **20** dynamically adjusts the position of the stripper plate **22** in relation to the mold **28** to ensure consistent timing of the movement of the stripper plate **22** in relation to the position of the mold **28**.

While the disclosed embodiment shows a separate wear plate **82** that can be removed, the wear plate **82** can be integrally formed with the fill plate **80**.

Many modifications and other embodiments of the disclosure set forth herein will come to mind to one skilled in the art to which these disclosed embodiments pertain having the benefit of the teachings presented in the foregoing descriptions and the associated drawings. Therefore, it is to be understood that the disclosure is not to be limited to the specific embodiments disclosed herein and that modifications and other embodiments are intended to be included within the scope of the disclosure. Moreover, although the foregoing descriptions and the associated drawings describe example embodiments in the context of certain example combinations of elements and/or functions, it should be appreciated that different combinations of elements and/or functions may be provided by alternative embodiments without departing from the scope of the disclosure. In this regard, for example, different combinations of elements and/or functions than those explicitly described above are also contemplated within the scope of the disclosure. Although specific terms are employed herein, they are used in a generic and descriptive sense only and not for purposes of limitation.

While particular embodiments are illustrated in and described with respect to the drawings, it is envisioned that those skilled in the art may devise various modifications without departing from the spirit and scope of the appended claims. It will therefore be appreciated that the scope of the disclosure and the appended claims is not limited to the specific embodiments illustrated in and discussed with respect to the drawings and that modifications and other embodiments are intended to be included within the scope of the disclosure and appended drawings. Moreover, although the foregoing descriptions and the associated drawings describe example embodiments in the context of certain example combinations of elements and/or functions, it should be appreciated that different combinations of elements and/or functions may be provided by alternative

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embodiments without departing from the scope of the disclosure and the appended claims.

What is claimed is:

1. A patty forming machine comprising:

- a pump box configured to receive food product therein;
- a fill plate having a plurality of holes therethrough through which food product is configured to pass;
- a stripper plate having a plurality of holes therethrough through which food product is configured to pass, the stripper plate being positioned between the pump box and the fill plate, the stripper plate being movable in a reciprocating manner relative to the fill plate and the pump box from a fill position to a non-fill position;
- a stripper plate sensor operatively coupled to the stripper plate, the stripper plate sensor configured to determine positions of the stripper plate;
- a mold comprising a wall having a plurality of mold cavities;
- a motor coupled to the mold and configured to continuously move the mold relative to the fill plate;
- a mold sensor operatively coupled to the mold, the mold sensor configured to determine positions of the mold; and
- a controller, having a processor and memory architecture, configured to:
  - compare the positions of the stripper plate and the mold based upon information received from the stripper plate sensor and the mold sensor, and
  - send a signal to move the stripper plate relative to the pump box and the fill plate from the non-fill position to the fill position when a predetermined position of the mold is determined.

2. The patty forming machine of claim 1, wherein the predetermined position of the mold is when the mold cavities are in the fill position.

3. The patty forming machine of claim 2, wherein the stripper plate is moved to the non-fill position a predetermined time before the mold cavities are moved to the eject position.

4. The patty forming machine of claim 2, wherein the stripper plate is moved to the fill position before the mold cavities are moved to the fill position.

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